

MMA Electrodes Chromium-Molybdenum steels

Rutile coated electrode for welding creep resistant steels used in the construction of pressure vessels, boilers and pipes, for operating temperatures of up to +500 °C. Easy arc striking and restiking. Very smooth and clean welds, blending into the base metal without undercut. Preheating, interpass temperature and post-weld heat treatment depend on the base metal.

Classification	
AWS	A5.5: E8013-G
EN	1599: E Mo R 12

Approvals	Grades
DB	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	0.60	0.30	-	-	-	-	0.50	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
PWHT 620 °C x 1 h	≥ 470	560-720	≥ 22	≥ 50	-

Materials

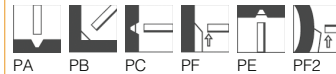
S(P)235-S(P)460, 16Mo3

Storage and redrying

Keep dry and avoid condensation. Re-drying not generally required.
If necessary: 100-110 °C for 1 hour

Current condition and welding position

AC; DC-



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	60-85	0,0	0,0
3,2	300	90-130	0,0	0,0
4,0	450	140-180	68,0	37,3
5,0	450	190-230	106,2	58,0